

Date: Friday, 3/16/2007 1:12:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number : 31251	
Estimate Number : 10834	
P.O. Number : N/A	Part Number : D29332
This Issue : 3/16/2007 S.O. No. : N/A	Drawing Number : D2933 UNDER REVIEW - C
Prsht Rev. : NC	Project Number : N/A CB 07.03/16
First Issue : 3/16/2007 Type : MACHINED PARTS	Drawing Revision : B C
Previous Run : 30487	Material : N/A
Written By : _____	Due Date : 3/30/2007 Qty: 8 Um: Each
Checked & Approved By : <u>HA 07.03.16</u>	
Comment : Est: B 00.06.26 New DWG rev (mpp 2069) EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	D6101001	7075-T7351 2X6X6.25
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Issue material from stock: 7075-T7351 QQ-A-250/12
 Cut Size 2.0 x 6.25 X 6.00
 Grain Along Long 6.00 Length
 Batch No: 25345

MS 07/03/22 8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 Program part number and batch number. En 07/03/24
 1-Inspect part number and batch number are programmed correctly. SA 07.03.24
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet
 5-Deburr

En 07/03/25

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

En 07/03/25

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

En 07/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/16/2007 1:13:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 31251

Part Number: D29332

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.25

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MSA

07-03-25 (8)

7.0

POWDER COATING

POWDER COATING



M 103706



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L

07/03/26

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/3/27 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/3/27 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/28

Job Completion



U 0703-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B <i>✓ C</i>		Page 1 of 1

07.03.16

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.126	0.123	0.122	0.122		
B	0.100	0.140		0.121	0.122	0.123	0.121		
C	0.100	0.140		0.136	0.134	0.130	0.128		
D	0.210	0.230		0.221	0.221	0.223	0.220		
E	1.245	1.255		1.247	1.246	1.246	1.250		
F	1.245	1.255		1.247	1.246	1.246	1.250		
G	2.495	2.505		2.500	2.501	2.497	2.501		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.573	1.575	1.575	1.577		
J	2.495	2.505		2.499	2.500	2.499	2.496		
K	0.257	0.262	DT8683	0.257	0.259	0.257	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.239	0.239		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.545	0.545	0.541	0.541		
P	0.490	0.510		0.498	0.495	0.496	0.496		
Q	3.715	3.725		3.719	3.718	3.710	3.720		
R	2.470	2.510		2.500	2.494	2.499	2.499		
S	0.240	0.270		0.255	0.253	0.254	0.254		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.627	1.630	1.630		
V	1.362	1.372		1.366	1.364	1.364	1.364		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.134	1.134	1.135	1.135		
Y	1.565	1.585	DT8695 A/B						
Z	5.990	6.010		6.004	6.002	6.001	6.002		
AA	0.015	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>Sp</i>
Date: 07/03/24

Audited by: <i>SA</i>
Date: 07.03.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF <i>TH</i>	<i>#</i>

SA

DART AEROSPACE LTD		Work Order:	
Description: 206 Saddle, Inboard, Right side		Part Number:	D2933-2
Inspection Dwg: D2933 Rev. B/C		Page 1 of 1	

CB 07.03.16

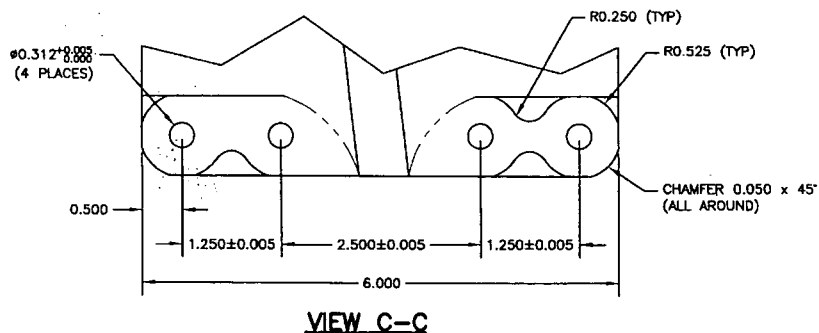
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.123	0.123	0.123	0.122		
B	0.100	0.140		0.120	0.121	0.123	0.123		
C	0.100	0.140		0.137	0.134	0.134	0.134		
D	0.210	0.230		0.219	0.220	0.221	0.222		
E	1.245	1.255		1.249	1.247	1.248	1.249		
F	1.245	1.255		1.249	1.247	1.248	1.249		
G	2.495	2.505		2.497	2.500	0.500	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.573	1.574	1.576	1.576		
J	2.495	2.505		2.499	2.499	2.497	2.479		
K	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
L	0.312	0.317	DT8686	0.315	0.315	0.315	0.315		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		?	?	?	?		
O	0.540	0.560		0.542	0.542	0.540	0.541		
P	0.490	0.510		0.497	0.498	0.495	0.495		
Q	3.715	3.725		3.719	3.718	3.719	3.719		
R	2.470	2.510		2.495	2.498	2.499	2.490		
S	0.240	0.270		0.253	0.254	0.254	0.254		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.627	1.627	1.627		
V	1.362	1.372		1.364	1.368	1.367	1.364		
W	0.316	0.321	DT8690	0.320	0.320	0.320	0.320		
X	1.125	1.145		1.132	1.134	1.135	1.137		
Y	1.565	1.585	DT8695 A/B						
Z	5.990	6.010		6.008	6.007	6.001	6.001		
AA	0.015	0.035		0.025	0.025	0.025	0.025		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	CR
Date:	07/03/25

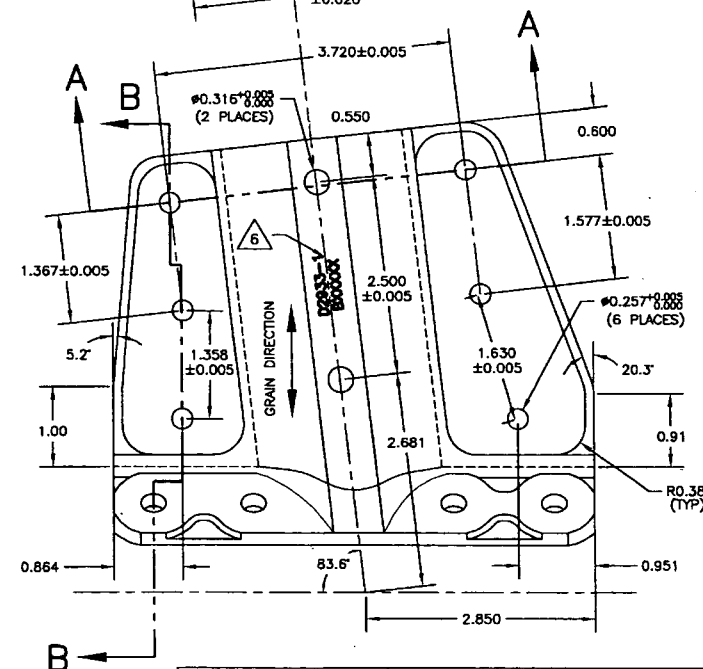
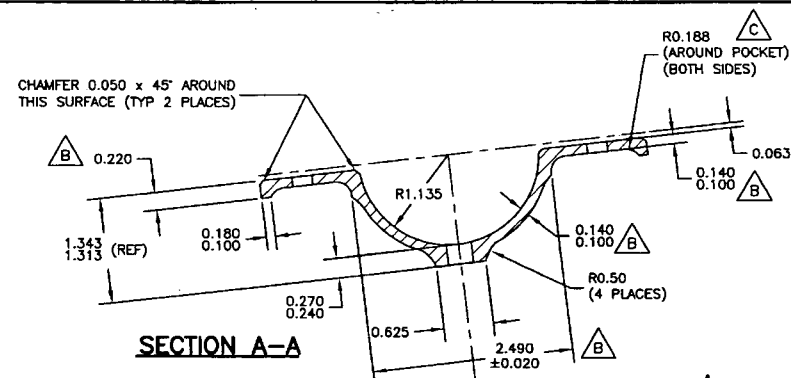
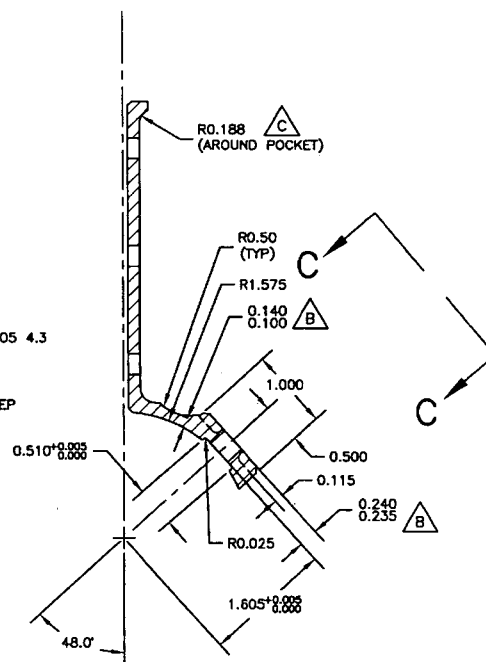
Audited by:	SA
Date:	07.03.25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC. BOLINGME, WA
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE

COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

REV. C
 SHEET 1 OF 1
 SCALE 2:3

RELEASED
 07.02.12

NO.

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

0270